

Work Order ID 84323

84323

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May-09-12 2:48:01 PM

Item ID: D3531-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 5/09/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/11/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	Rev A

100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3531								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating									

MU7338

8-15
 START TIME: *3200 F* OVEN TEMPERATURE: *8-45*
 FINISH TIME:

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Item ID: D3531-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 5/09/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

1 ϕ BL 12-5-11.

140

Identify as per dwg & Stock Location 227

0.00

140

Packaging

Memo

0.00

Packaging

1 12/5/11 ϕ

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCJ 12/05/11

ME
12-05-10

Picklist Print

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Work Order ID: 84323

Parent Item: D3531-041

Parent Item Name: Bracket Assembly

Start Date: 5/09/12

Required Date: 5/11/12

Start Qty: 1.00

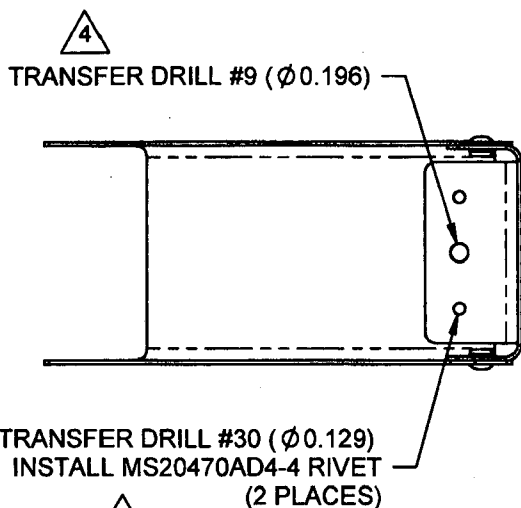
Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

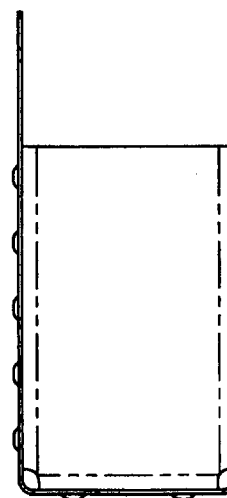
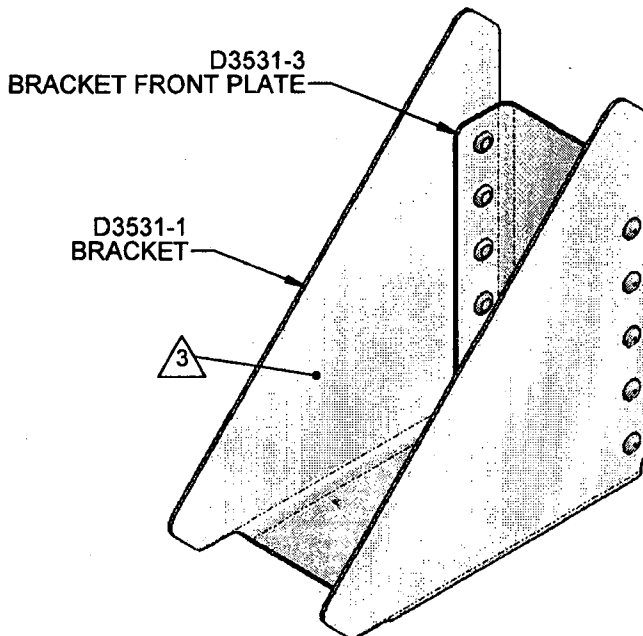
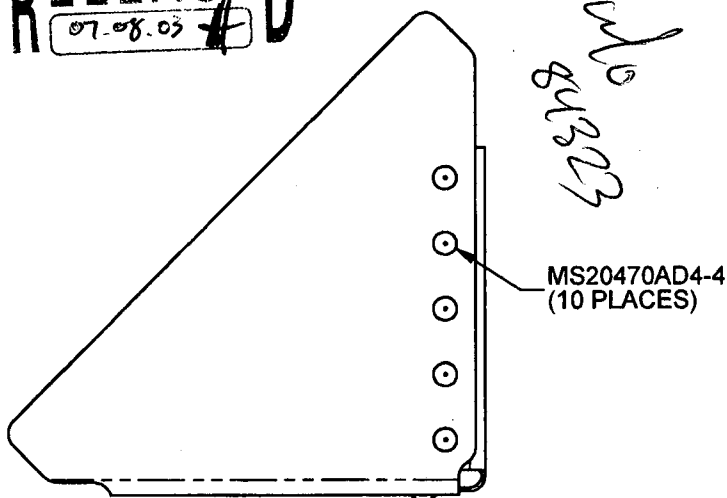
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 Bracket		Manufactured	No			100	Each	1.0000	1	1		5/12/05/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				77700		1							
D3531-3 Bracket Front Plate		Manufactured	No			100	Each	1.0000	1	1		5/12/05/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				61781		0							
				71978		1							
MS20470AD4-4 Rivet, Universal Head		Purchased	No			100	Each	6,567.0000	12	12		5/12/05/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		6567							
				116188		136							
				116391		66							
				118614		1046							
				119109		26							
				120361		288							
				121011		5							
				121556		2000							
				121652		3000							



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED A	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	



RELEASED
07-08-03



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

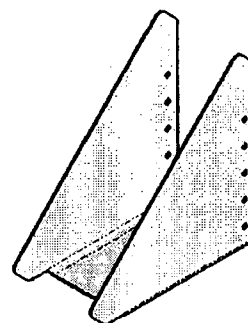
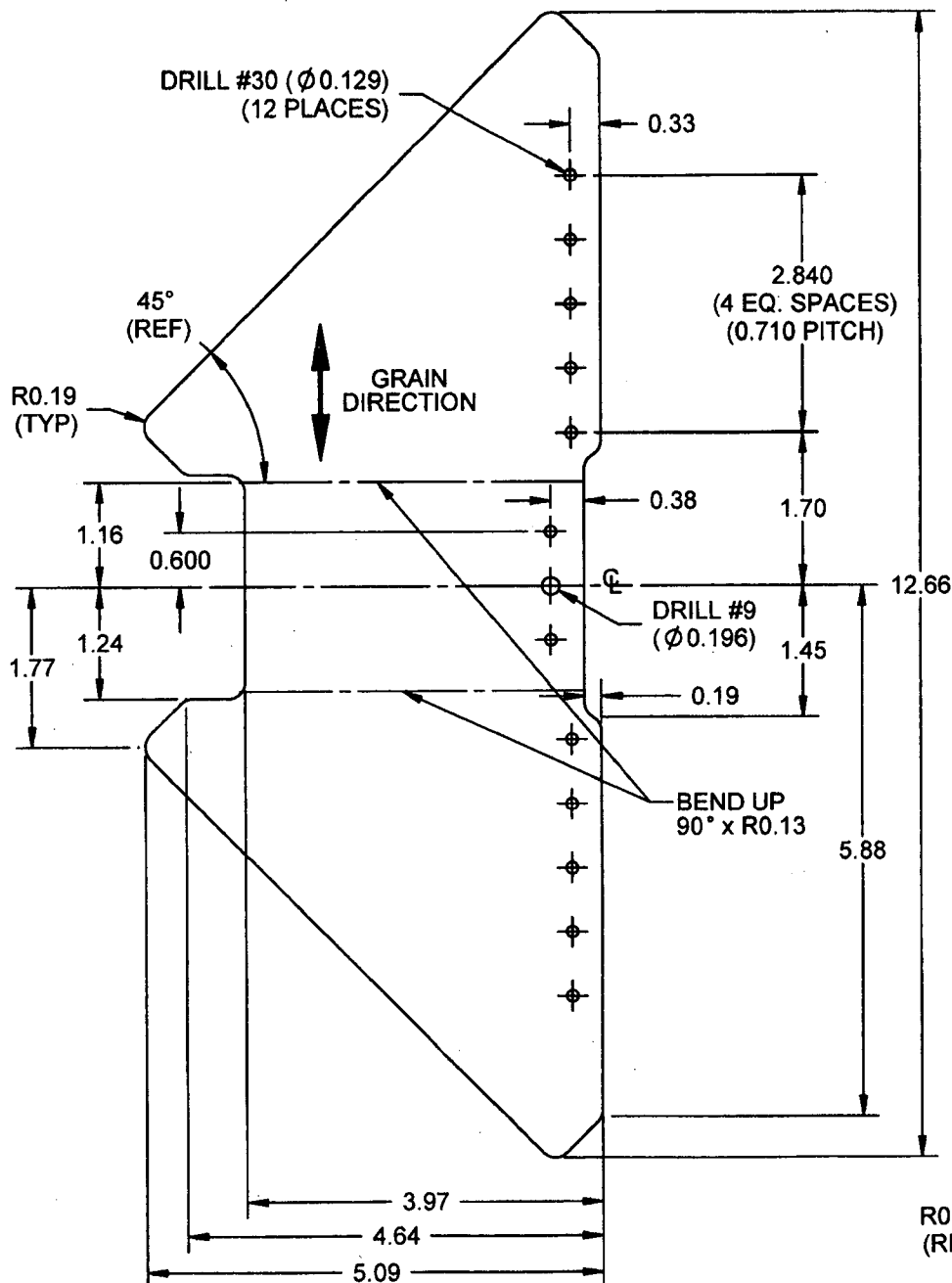
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A
DATE 07.06.19	TITLE BRACKET ASSEMBLY	SHEET 2 OF 3 SCALE 1:2	



RELEASED
07-08-03

D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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